

Date: Thursday, 17/07/2008 1:19:52 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE  
 Job Number : 40593  
 Estimate Number : 13420  
 P.O. Number :  
 This Issue : 17/07/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : PB6743001207  
 First Issue : 11 Type : LARGE FAB ASSY Drawing Number : B6743001 P.5/ P.16  
 Previous Run : Material :  
 Written By : Due Date : 24/07/2008 Qty: 4 Um: Each  
 Checked & Approved By : MF 08-07-17  
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6TS1000W125 6061T6 SQ TUBE 1.00 x 1.00 x .125w



Comment: Qty.: 1.9469 f(s)/Unit Total : 9.7346 f(s)

6061T6 SQ TUBE 1.00X.125

batch: 108626

SAD

08/07/17

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.090" chamfer on both ends of tube

3- deburr

SAD

08/07/17

(x4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD

08/07/18

(x4)

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

JL

08/07/27

(x4)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD

08/07/28

(x4)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 40593

Part Number: PB6743001207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

batch:

B40272 V

SP

08-07-28

(6X)

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Square Cap

batch:

B40042 V

SP

08-07-28

(4X)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

SP

08-07-29

(4X)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

SP

08-07-29

(4X)

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

01/7/29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

01/7/29

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W17

08-07-31

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)

080805/08

MF 08-08-05

